



Dart Aerospace Ltd.
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D5522-042
Job Sheet 188584



008540

Part No: D5522-042

Job Qty: 4 ea

Part Name: Oil Drain Valve Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/11/19

Job Tracking No:

Due Date: 1/25/19

Created By: Jesse White

Type: SOLD

Description:

Note: D5522 REV.C IPP Rev: A RQ 17.04.12 Verified by: DD IPP REV:B 17.05.12 AS PER DWG REV.A DD
VERF:JFS IPP REV:C 17.09.19 AS PER DWG REV.C DD VERF:JFS IPP REV:D 17.11.17 MODIFY
PROCESS AND BOM AS PER INTUITIVE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/25/19	0.00	0.00	Start Up Small Fab-4		DAS 58
140	Small Fab	4 pcs		1/25/19	0.00	4.86	Small Fab-4		9-89 58 DAS
150	QC	4 pcs		1/25/19	0.00	0.00	QC5		MAR 0 8 2019 40
160	Packaging	4 pcs		1/25/19	0.00	0.00	Packaging3-2	5+166	9-89 58 DAS
170	QC21-SA	4 Ea		1/25/19	0.00	0.00	QC21		MAR 1 1 2019 9-89 58 DAS

Part Op 140 - ***BEFORE ASSEMBLY VERIFY IF THE PART IS CLEAN INSIDE*** Assemble D5522-042 as per Dwg D5522, Descriptions: note 8-9-10,11,12.*** 1- INSTALL D5527-1 AS PER DWG WITH PERMATEX THREAD SEALANT. TORQUE AS PER DWG NOTE 8. BATCH: m13785 VERIFY TORQUE BY: 58 *****BEFORE INSTALLING AN814-4J PLUG AND D5530-1 FITTING REMOVE ORINGS (SCRAP THEM) AND REPLACE THEM WITH M83248/1-012 PACKING***** 2- INSTALL AN814-4J PLUG, D5370-1 AND D5530-1 FITTING AS PER DWG WITH OIL LUB 2380. TORQUE AS PER DWG NOTE 9. 2380 BATCH: m137872 VERIFY TORQUE BY: 58 3- LOCKWIRE AS PER DWG, SEE NOTE 10. 4- ATTACH VALVE CAP WITH LANDYARD AS PER DWG NOTE 11. (PICK CBL460 AND CBL1240)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN814-4JL	Plug	4 Ea (1 ea)	90-Start up Operation	506069B
CBL-1240	Cable	4 ft (1 ea)	90-Start up Operation	5113791
CBL-460	Loop Sleeve	16 Ea (4 ea)	90-Start up Operation	5142627
D5522-1	Oil Drain Valve Mount	4 Ea (1 ea)	90-Start up Operation	5147265
D5527-1	Oil Drain Valve	8 pcs (2 ea)	90-Start up Operation	5145375
D5530-1	37° Flared Tube Fitting	4 pcs (1 ea)	90-Start up Operation	5156858
D5532-041	Valve Cap Assembly	8 pcs (2 ea)	90-Start up Operation	5145373
M83248/1-012	Packing	8 Ea (2 ea)	90-Start up Operation	5087815
AS3208-06	Packing	4 Ea (1 ea)	90-Start up Operation	5001689
D5370-1	Fitting	4 pcs (1 ea)	90-Start up Operation	5145207

ST 826

2

51167

51167

51167

80A

ST 550

ST 159

5147265

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	☐ OTHER :	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN814-4JL	4	17	0
	AS3208-06	4	152	0
	CBL-1240	4	207	0
	CBL-460	16	358	0
	D5370-1	4	22	0
	D5522-1	4	0	0
	D5527-1	8	6	0
	D5530-1	4	10	0
	D5532-041	8	8	0
	M83248/1-012	8	102	0
Part Specifications				
Specifications could not be found.				

Plex 1/11/19 9:14 AM dart.white.jesse

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																			
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 Container No: S160662 Part: D5522 - 042 Job No: 188584 Serial No/Batch: S160662 Revision: C Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 03/09/15		Lead hand / Supervisor Approval Verification																																					
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